

Work Order ID 71805

Tuesday, July 12, 2011 11:26:23 AM



Page 1

Item ID: D3826-041

Accept



Setup Start



Revision ID:

Item Name: Rib / Gusset Assembly

Stop



Start Date: 7/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

P

Date: 11-07-12 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3826	Rev B								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- use DT9434 to assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod Batch: <i>M114649</i>								
110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

PB 11/07/20 *(8)*
CF 11.07.20

11.07.20 *(6)*

(46)

Sub 7/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *622*

0.00



Packaging

Memo

0.00

Packaging

SAD 17-07-20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/7/25**MF 11-07-21*

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, July 12, 2011 11:28:24 AM

Page 1

Work Order ID: 71805

Parent Item: D3826-041

Parent Item Name: Rib / Gusset Assembly



Start Date: 7/12/2011

Required Date: 7/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2235-1 Manufactured No



Basket Rib

Location	Loc Qty	Loc Code
WA	2	
70669	2	
WA005	4	
66895	4	

6 pb 11/07/18

B71530 → (6)

D3929-041 Manufactured No



Gusset Assembly

Location	Loc Qty	Loc Code
WA	3	
70670	3	

6 pb 11/07/18

B71612 → (3) (3)

D3929-042 Manufactured No



Gusset Assembly

Location	Loc Qty	Loc Code
WA	3	
70672	3	

6 pb 11/07/18

B71613 → (4) (5)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

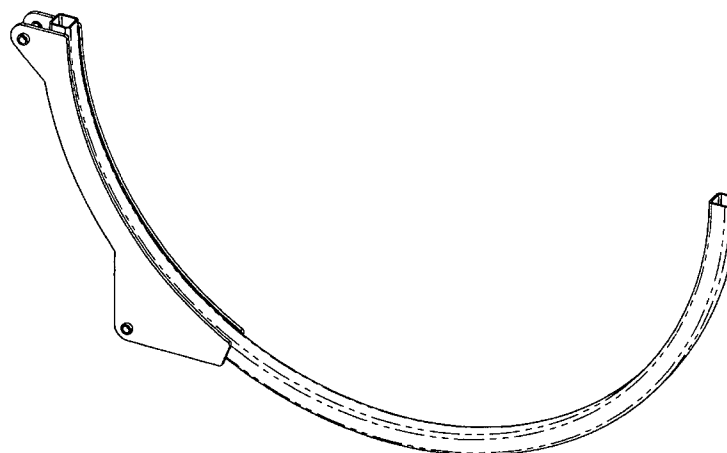
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY. .041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△B



D3826-041 RIB/GUSSET ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71803

02-7

RELEASED
09/04/12

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 3.32 lbs

△B

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JS</i>		
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>		
MFG. APPR.	<i>JS</i>		
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
DATE	09.04.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3826** REV. B
SHEET 1 OF 2

TITLE **RIB/GUSSET ASSY** SCALE
NTS

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8 7 6 5 4 3 2 1

△ B D3929-042
GUSSET ASSEMBLY

△ B D3929-041
GUSSET ASSEMBLY

TYP

11805

0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

RELEASED
9/10/12

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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